

Date: Wednesday, 31/01/2007 3:02:38 PM  
 User: Linda Lacelle

## Process Sheet

Customer	CC-DAR01	Dart Aerospace Ltd.	Drawing Name	D412-742-013
Job Number	30472		Part Number	D412742013
Estimate Number	10804		Drawing Number	DSI 9369 9364 R1 07.01-31
P.O. Number	:		Project Number	:
This Issue	31/01/2007	S.O. No. :	Drawing Revision	:
Prsh't Rev.	NC		Material	:
First Issue	26/01/2007	Type : LANDING GEAR	Due Date	02/02/2007
Previous Run	00015		Qty:	1
Written By	:		Um:	Each
Checked & Approved By	:			
Comment	:			
<b>Additional Product</b>				
Job Number: 				
Seq. #:	Machine Or Operation:	Description :		
1.0	LANDING GEAR 1 	LANDING GEAR RESOURCE 1 		
<p><b>Comment:</b> LANDING GEAR RESOURCE 1        REMOVE FROM STK:  <u>D412-742-013 B 29926</u></p>				
2.0	LANDING GEAR 1 	LANDING GEAR RESOURCE 1 		
<p><b>Comment:</b> LANDING GEAR RESOURCE 1        A) -DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364. ENSURE WEARPLATE IS INSTALLED.        -TEST FIT D3591-1 BUSHING AND SADDLES.        -REMOVE D3591-1 BUSHINGS  <u>D3591-1 B 30571</u></p> <p>B) - REMOVE D3391-021 FWD TUBE AND DEBURR ALL HOLES        - TOUCH UP ALODINE</p> <p>C) - RE-INSERT D3391-021 FWD TUBE. INSTALL WEARPLATES.        COAT BUSHINGS WITH LPS3 B <u>17168</u>        INSTALL BUSHINGS - TEST FIT SADDLE HARDWARE</p>				
3.0	QC5 	INSPECT WORK TO CURRENT STEP 		
<p><b>Comment:</b> INSPECT WORK TO CURRENT STEP</p>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 31/01/2007 3:02:38 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 30472

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 REINSPECT KIT FOR 100% COMPLETENESS</p>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 REPACKAGE PER PPP USING NEW B/N. NEW PAPERWORK &amp; LABELS REQ'D CHG002 -ENSURE DSI PAPERWORK IS INCLUDED-</p>		
6.0	QC21	FINAL INSPECTION/W/O RELEASE
<p>Comment: FINAL INSPECTION/W/O RELEASE</p>		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 10:09:57 AM  
 User: Linda Lacelle

## Process Sheet

Customer	CC-DAR01	Dart Aerospace Ltd.	Drawing Name	D412-742-013		
Job Number	30472					
Estimate Number	10804					
P.O. Number						
This Issue	26/01/2007	S.O. No.	:	Part Number	D412742013	
Prsht Rev.	NC	Type	LANDING GEAR	Drawing Number	DSI 9369 9364 PH 07.01.31	
First Issue	/ /	Material		Project Number	:	
Previous Run	00015	Drawing Revision		Due Date	02/02/2007	Qty: 1 Um: Each
Written By						
Checked & Approved By						
Comment						

## Additional Product

Job Number:



LUG 002

Seq. #:	Machine Or Operation:	Description :	
1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
	Comment: LANDING GEAR RESOURCE 1 REMOVE FROM STK: D412-742-013 B		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
	Comment: LANDING GEAR RESOURCE 1 A) -DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS 2364 SHOWN ON DSI 9369. ENSURE WEARPLATE IS INSTALLED. -TEST FIT D3591-1 BUSHING AND SADDLES. -REMOVE D3591-1 BUSHINGS D3591-1 B		
	B) - REMOVE D3391-021 FWD TUBE AND DEBURR ALL HOLES - TOUCH UP ALODINE		
	C) - RE-INSERT D3391-021 FWD TUBE. INSTALL WEARPLATES. <i>COAT BUSHINGS WITH LPS-3 PH 07.01.31</i> INSTALL BUSHINGS - TEST FIT SADDLE HARDWARE		
3.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP		
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 REINSPECT KIT FOR 100% COMPLETENESS		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 10:09:58 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 30472

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP USING NEW B/N.

NEW PAPERWORK & LABELS REQ'D

*CHG 002 PH 07.01.31*

-ENSURE DSI PAPERWORK IS INCLUDED-

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. DSI 9364	REV. A	SHEET 1 OF 1
DATE 07.01.16		TITLE BUSHING INSTALLATION	SCALE NTS	
A	07.01.16	NEW ISSUE		

## DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. B AND ICA-D412-742 REV. 1

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

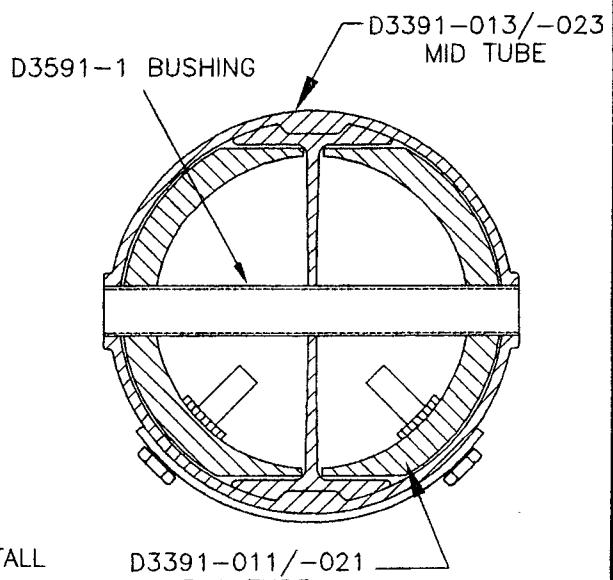
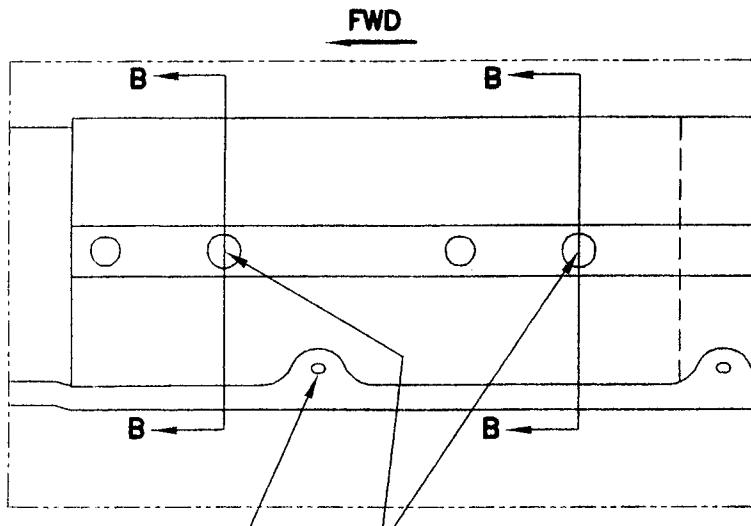
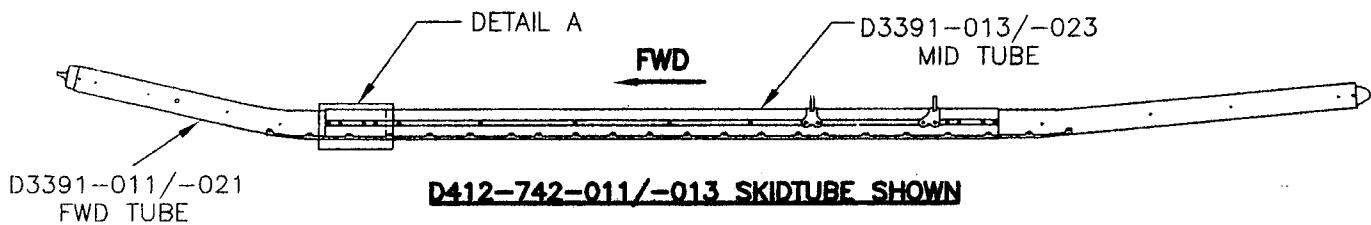
REFERENCE ONLY

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ( $\varnothing 0.500$ ) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



**DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION**

**SECTION B-B**

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